Work Orde July-31-12 12:4	er ID 88243 3:08 PM		*88	243*				Page 1
Item ID: Revision ID:	D206-781-023		Accept	*N900	<u>04010</u>	ገ* ፡	Setup Start	14771
Item Name:	Floor Protector (Passenger Cabin)						Stop	*NS2*
Required Date:	7/24/12 Start Qty: 1.0 8/17/12 Req'd Qty: 1.0	*1°	k k	Cust Item I Customer:	D:			
Reference: Approvals:	Process Plan: MLJ	Nate: 17 / 05	ろして Tooling:	Da	ate:	1	Run Start	*NR1*
Approvais.	QC:	ı	1		ate:		Stop	*NR2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
Draw Nbr	Revision Nbr							•
100	S-100-10-10-10-10-10-10-10-10-10-10-10-10		0.00				10/	
100			16	roloilog		9	14A	BG 12-9-6
DC Document Control	Memo Photoco CHG 0	opy bluefile &type labels 01		10409		· C		/
110	Pick Kit		0.00				1./	12/9/06
110 Packaging Packaging	Memo		0.00			-		19/1/3
	N.							
120	QC4- 100% Inspect	t kits for completeness	0.00	AS (7/09/94)				
120 QC Quality Control	Memo		0.00	6 17/soly			Y	

NCR:	Yes	/	No	

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE	•	······································	
											QA Closed:	Date:	
Work Ord	er:				-	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR						Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
IVCI	10.				- 	Work Order Opdate			Large Fau	Composite	_	3uphilei	J
Root					Descr	ription of work order update	1	Initial	Acti		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descri	iption	Date .	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining								* AM					
							FAUL	T CATE	GORY				
Landi		1			_	General	_	ו		_	7		,
		Bending Centre No Cracks Crushed/O Cuffs		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		- 1 `	on Incomplete ions Incomplete/U	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea	ıt		-	Countersink		Mislabe		1	Positioned V	Vrong	1
	_	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	_	Other
		Ripples in				Drill Holes		Offset			⊿ ′		<u></u>
		Torque W	aves in E	xtrusio	n	Drawing		Out of C	Calibration				
		Turning So	equence			Finish	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde <i>July-31-12 12:4.</i>		3243		*882	243*						Page 2
Revision ID:	D206-781-0	or (Passenger Cabin)		Accept	*N900	040	100)* s	Setup Star Stop	IV	S1* S2*
	7/24/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:		lan:	Date:	Tooling: SPC (Y/N):		ate:		Ĭ	Run Star Sto	" []	R1* R2*
Sequence ID/ Work Center ID 130 *130* Packaging Packaging	•	Operation Description Memo Identify and	pack for shipping as per	Set Up/ Run Hours 0.00 0.00 PPP D206-781-023	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

140

Quality Control

12/9/11 des

NCR:	Yes	1	No
	1 - 3	,	

												DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDE	R NON-CO	ONF	ORN	/ANCE / UPI	DATE	·		· .
										-		QA Closed:	Date:	
Vork Ord	or.					DISPOSI	TION				AGAINST DE	EPARTMENT,	PROCESS	
· · · · · · · · · · · · · · · · · · ·							Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part I	No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						U	se-as-is	7	Therm	oforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	۱o.					Work Order	Update	1		Large Fab	Composite]	Supplier	
Doot					Danas	inting of words and			4:-1	Λ -4	:	C: 0		
Root Cause		Date	Step	Qty	1	iption of work orde or Non-conforman			tial f Eng		tion ription	Sign & Date	Verification	QC Inspector
oc/Data		Date	step	Qty		Of Non-comorman	.e '	Cille	LIIE	Desci	iption	Date	verification	QC ITISPECTOI
uip/Tooling														
perator							}							
laterial														}
etup														
ther														
rocess							,							
upplier														
raining														
napproved										*				
							FA	ULT	CATE	GORY				
Landi	ng (Gear			_	General	· 							_
		Bending				Bend		G	rain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		на	ardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	_	ln	specti	on Incomplete	<u></u>	Part Incorred	t	Weld
		Crushed/C	Crimped.		_	Burrs		_		ons Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			_	Contamination				nance		Part Moved		
		Heat Treat			_	Countersink		M	lislabe	led		Positioned V		7
		Inspection		Tube		Cut Too Short	_	_	lisread			Power Loss/	Surge	Other
		Ripples in				Drill Holes		→	ffset					- 4
		Torque W			n L	Drawing		_ 0	ut of C	alibration				
		Turning Se				Finish		_ 0	ut of S	equence				· · · · · · · · · · · · · · · · · · ·
		Wave/Twi	ist in Tub	e	1	Folio		0	utside	Dimensions				

Picklist Print July-31-12 12:43:00	8 PM										Page
Work Order ID:	88243										
Parent Item:	D206-781-023			· ,			Star	rt Date: 7/24/1	2	Required Da	ate: 8/17/12
Parent Item Name:	Floor Protector (Pas	ssenger Cabin)		•			Sta	ort Qty: 1.00]		Required Q	
Comments:	IPP RevA: New issu verified by:EC	ue DD verified by:	EC	IPP Rev:B add commen	t for d3800 I	DD 10.03.0	8				
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin- Item	Primary Last Location Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3898-1 Floor Protector (206L)		Manufactured	No		110	Each	0.0000		42	ラコリ	10 8824
D3934-041 Clip Assembly		Manufactured	No		110	Each	8.0000	(2)	2 🔾	/	
•				Location	Loc Qty	<u>Lo</u>	c Code				
				ST072	8					/	
				67931	8				573	_	
D3800-1-100 Hook and Loop Strip (1"	Soft)	Manufactured	No	——————————————————————————————————————	110	f	265.8474	8.333	8.333		
	7			Location	Loc Qty	Lo	c Code				
Cat_2_at~	Sb. 60"			ST063	215.8454						
1	2 . 4 . 4 . 4 . 4			68910	9.801						
661 KJ	-) NEASOLE)			72233	9.841						
<u> </u>	Enluslac			80073	1.1734			-	16.6	,	
\mathcal{N}				<u>85354</u>	195.03			18.	<u> </u>	`	
				ST088	50.002						_
				84060	50.002						
D3800-3-100 Hook and Loop Strip (1"	Hard)	Manufactured	No		110	f	255.6460	8.333	8.333		
1ν	•			Location	Loc Oty	<u>La</u>	oc Code				
	to a			ST063	255.646						
	N 30 .00			68915	18.301						
L'4				72771	2.341						
per Kit	neasur)			73007	5.001						
V	Sizialor.			75105	13.67						
	(04			80077	15.536						
				84061	9.967			Q	<u>216</u> .6	7	
				85355	190.83			8	3 " S	7	1 1

NCR:	Yes	1	No
IVCIV.	162	/	NO

											DQA:	Date	:
NCR:	Yes	/ No					WORK ORDER NON-C	O	VFOR	MANCE / UPDATE			2 1
											QA Closed:	Date	:
Work Ord	er:					١	DISPOSITION			AGAINST E	EPARTMENT,	PROCESS	
							Rework]		Skid-tube Crosstube		Water Jet	Engineering
Part	No.						Scrap		1	Machining Small Fab	Pro	d. Eng. Coor.	Quality
						1	Use-as-is		i	noforming Finishing	_	e/Packaging	Other
NCR	No.					١	Work Order Update			Large Fab Composite	┦ `	Supplier	
Root	i				Desc		tion of work order update	l	nitial	Action	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data	<u> </u>												
quip/Tooling	<u> </u>												
perator	<u> </u>												
laterial	<u> </u>												
etup	<u> </u>							i					
ther	\vdash												
rocess	H												
upplier	-												
raining													
napproved								<u> </u>	T CATE	CODY		<u> </u>	
Land	na (General	HUL	I CATE	GORT		· · · · · · · · · · · · · · · · · · ·	
Lanu	TE (Bending			Γ		Bend		Grain	Г	Ovalized	Г	Pressure/Forced
	-	Centre No	nt Concer	ntric to (0/5	-	BOM/Route		Hardwa	ire -	Over/Under	tolerance	Temperature/Cure
		Cracks	e concer		-		Broken/Damaged		1	ion Incomplete	Part Incorre	 	Weld
		Crushed/0	Crimped		F	\neg	Burrs		1	tions Incomplete/Unclear	Part Lost/M	 	Wrong Stock Pulled
		Cuffs			.	-	Contamination	H	Mainte	' '	Part Moved		
		Heat Trea	t		r	_	Countersink		Mislabe	-	Positioned V	Vrong	
		Inspection		Tube	T	-	Cut Too Short		Misread	<u> </u>	Power Loss/		Other
	T	Ripples in	•		<u> </u>	—	Drill Holes		Offset	L		·	
		Torque W	aves in E	xtrusio	n	ᅦ	Drawing		Out of (Calibration			
		Turning Se	equence		Ī		Finish		Out of S	Sequence			•

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

July-31-12 12:43:08 PM

Page 2

Work Order ID:

88243

Parent Item:

D206-781-023

Parent Item Name:

Floor Protector (Passenger Cabin)

Start Date: 7/24/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

AN525-10R6

Purchased

No

110

Each

151.0000

4

*8

Screw

Location	Loc Oty	Loc Code		
ST345	. 125			
1208	33_ 25		<u> </u>	
1221	51 100	•		•
ST346	26			- 1
1187	257 23			12/9
1193	309			12/

												DQA:	Date:	*,	
NCR: Y	'es	/ No				WORK ORDER NON-C	O	NFORI	MANCE / U	JPD	ATE	QA Closed:	 Date:	ا و د	ę
Work Orde	er:					DISPOSITION					AGAINST DE				_
	_					Rework]		Skid-tube]	Crosstube		Water Jet	Engineering	_
Part N	lo					Scrap			Machining		Small Fab	Pro	d. Eng. Coor.	Quality	
	_					Use-as-is		Thern	noforming		Finishing	Rec/Sto	re/Packaging	Other	
NCR N	10					Work Order Update]		Large Fab]	Composite		Supplier		
Root					Descri	ption of work order update		Initial	,	Actio	on	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	De	scri	ption	Date	Verification	QC Inspect	or
Doc/Data															
Equip/Tooling														1	
Operator															
Material [

FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Maintenance Cuffs Contamination Part Moved Countersink Mislabeled Positioned Wrong Heat Treat Inspection Strip in Tube Cut Too Short Power Loss/Surge Other Misread Ripples in Bend Drill Holes Öffset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions**

Setup Other Process Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD.

5.0 PARTS LIST

REFERENCE ONLY

5.1 BELL 206 A/B



Qty -051	Qty -011	Qty -021	Part Number	Description
Х			D206-781-051	FLOOR PROTECTOR KIT (PILOT, CO-PILOT, PASSENGER CABIN)
1	Х		D206-781-011	FLOOR PROTECTOR KIT (PILOT AND CO-PILOT)
1		Х	D206-781-021	FLOOR PROTECTOR KIT (PASSENGER CABIN)
	1		D3874-1	FLOOR PROTECTOR, CO-PILOT
	1		D3874-2	FLOOR PROTECTOR, PILOT
-	1	1	D3875-1	FLOOR PROTECTOR, PASSENGER
		2	D3934-041	CLIP ASSEMBLY
	4		D3800-1-100-300	LOOP STRIP
	4		D3800-3-100-300	HOOK STRIP
		2	D3800-1-100-500	LOOP STRIP
		2	D3800-3-100-500	HOOK STRIP
	2	 	AN4-13A	BOLT
		4	AN525-10R6	SCREW
	2		AN960JD416	WASHER
	2		NAS43DD4-20	SPACER
	1		NAS43DD4-64	SPACER

5.2 BELL 206 L/L1/L3/L4

Qty -053	Qty -011	Qty -023	Part Number	Description
Х			D206-781-053	FLOOR PROTECTOR KIT (PILOT, CO-PILOT, PASSENGER CABIN)
1	х		D206-781-011	FLOOR PROTECTOR KIT (PILOT AND CO-PILOT)
1		Х	D206-781-023	FLOOR PROTECTOR KIT (PASSENGER CABIN)
	1		D3874-1	FLOOR PROTECTOR, CO-PILOT
	1		D3874-2	FLOOR PROTECTOR, PILOT
		21	D3898-1	FLOOR PROTECTOR, PASSENGER
		2	D3934-041	CLIP ASSEMBLY
	4		D3800-1-100-300	LOOP STRIP
	4		_D3800-3-100-300	HOOK STRIP
		1 2	D3800-1-100-500	LOOP STRIP
		12	D3800-3-100-500	HOOK STRIP
	2	-	AN4-13A	BOLT
	<u> </u>	14-	AN525-10R6	SCREW
	2	1	AN960JD416	WASHER
	2		NAS43DD4-20	SPACER
	1		NAS43DD4-64	SPACER